

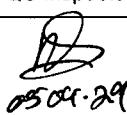
52

DART AEROSPACE LTD	Work Order:	22024
Description: Doubler	Part Number:	D3144-121
Dwg: D3144 Rev. B page 7 04.12.01 ADT	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PF	04.12.08	10
2	PG	Issue P/O: <u>7007542</u> Email or Ship DXF file to vendor Laser Cut D3144-121 flat pattern per Dwg D3144 Possible Supplier: GFI or Industrial Laser Material release note is required			
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CD	05/03/01	10
4	QC6	Inspect dimensions as per Dwg D3144	TRF	05.03.10	9
5	GA	Deburr	SB	05/04/12	9
6	FP	Chemical Conversion Coat per QSI 005 4.1	MWL	05-04-15	9
7	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) per QSI 005 4.3	MFP	05/04/25	9
8	QC3	Inspect Powder Coat	MH	05-04-25	9
9	ST	Identify and Stock	MWL	05-04-25	9
10	AC	Cost / part: <u>Z1, Z3</u>	SAC	05-04-26	9
11	DC	Close W/O <u>Z1, 06</u> Inspect Level 21	PF	05.04.29	9

Rev	Date	Change	Revised By	Approved
A	04.11.29	New issue	KJ/RF	<i>[Signature]</i>

RELEASED
[Signature]
04.11.30

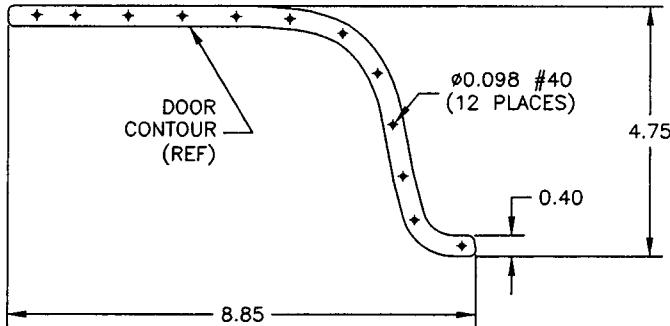
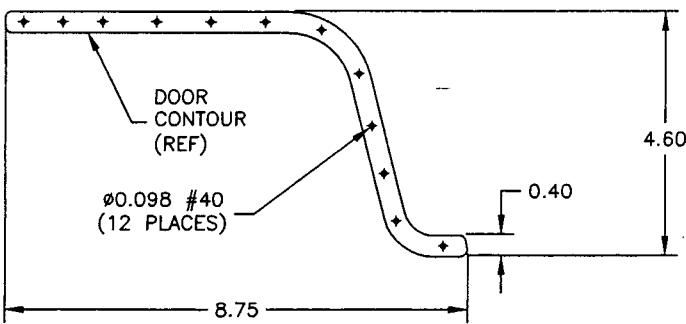
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05.03.10	4	KEPT IN STORES FOR TEMPLATE	RF	05.03.10	1	RF 05.03.10	 05.03.10	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DARTOACOPY IS
ISSUED

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3144	REV. B SHEET 7 OF 9
DATE 04.09.17	TITLE DOUBLER	SCALE NTS	

RELEASED
04.11.23**D3144-107 DOUBLER (FOR D412-694-03)****D3144-121 DOUBLER (FOR D412-694-04)**

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. Z2024

D3144-107/-121 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-B7.DWG"

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No	:	0022024	Department Code:
Project Name	:	D3144-121	Burden Flags : NNNNNNNN
Project For	:	WK452	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3144-121	Invoice Number :
Description	:	Doubler	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	10	
Amount Done	:	0	Order Entry No :
Start Date	:	12-03-04	OE Value : 0.00
Est Finish Date	:	12-21-04	
Act Finish Date	:		Est Margin : 0.000%
Drawings Rqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0124332 SHIPPING MEMO 0292749

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>10 PCS</u>	<u>2007542</u>	<u>D3144-121</u>		<u>DOUBLER</u>	<u>B</u>

MATERIAL	SUPPLIED BY	MAT. REL. NO.
<u>AL 2024-T3 (QQ-A-250/4)</u>	<u>SAMUEL / KAISER ALUMINUM</u>	<u>226511 ATT'D</u>

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 24 FEBRUARY 2005

G.F.I. Q.C. REP.

007-05



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 7 JANVIER 2005

Company Name: G.F.I. Division of Thomas & Betts, Limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058243

de commande SSMQ: 834566

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Z otre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
2	2	.032" x 48" x 144"	2024 T3	AMS-QQ-A-250/4	226511

Bien à vous,
Yours truly,

José Raymond

Commis à l'administration.
Administration Clerk.



SHIP TO:
 LES METAUX SPECIALISES SAMUEL
 (SHIP TO)
 21525 CLARK GRAHAM
 BAIE D'URFE, PQ, CA H9X3T5

SOLD TO:
 SAMUEL SON & CO LTD
 2225 FRANCIS HUGHES
 LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4011938

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		SHIPPING RUN #/LOAD ID:		GOVT CONTRACT NUMBER:	
N16221				100089/2			
KAISER ORDER NO:	LINE ITEM:		SHIP DATE:	ALLOY:	CLAD:	TEMPER:	
1008983	1		9-JUL-2004	2024	BARE	T3	
WEIGHT SHIPPED:	QUANTITY:		B/L NUMBER:	GAUGE:	WIDTH:	LENGTH:	
3928 LB	173 PCS EST.		202031	0.0320 IN	48.00 IN	144.000 IN	

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 226511 Cast

Drop

Ingot

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	67.4 : 67.6 (465 : 466)	45.2 : 45.3 (312 : 312)	17.8 : 18.3

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.22	4.46	0.55	1.32	0.01	0.17	0.01	0.01	0.00	TOT 0.06

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772 (MIL-H-6088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR